Factory Production Control Audit Report

for

Precision Fabrications Andover Ltd

Covering the following Standard

EN1090-1:2009 “Requirements for Conformity Assessment of Structural Components”

For the audit carried out on the following date(s)

17/02/2023

Audit reference number(s)

22/0546

Centre for Assessment Ltd.
Lee House, 90 Great Bridgewater Street, Manchester, M1 5JW
Tel: +44 (0) 161 237 4080
e-mail: iso@centreforassessment.co.uk
web: www.centreforassessment.co.uk

AUDIT DETAILS

MAIN LOCATION ADDRESS	Unit 9, North Way Walworth Industrial Estate Andover SP105AZ
TOTAL NUMBER OF OTHER LOCATIONS	0
ADDRESS(ES) OF OTHER LOCATION(S)	N/A
LOCATION(S) AUDITED	Unit 9, North Way Walworth Industrial Estate Andover SP105AZ
TOTAL NUMBER OF EMPLOYEES	24 THOSE INVOLVED IN EN1090 WITHIN TOTAL 10
CLIENT REPRESENTATIVE	David Seabury TELEPHONE 01264 316 339
CLIENT EMAIL	david@pfandover.com
LEAD AUDITOR	Fabian Mendez TELEPHONE 07883295541
LEAD AUDITOR EMAIL	fabian.mendez.oms@gmail.com
AUDITOR	N/A
OBSERVER	N/A
TOTAL NUMBER OF AUDITOR DAYS	1 day
TYPE OF EN1090-1 AUDIT	surveillance
RECOMMENDED SCOPE (FOR THE CERTIFICATE)	Fabrication of structural steelwork to EXC2
EXCLUSIONS	Design
CERTIFICATED EXECUTION CLASS	EXC 2
RWC NAME AND JOB TITLE	Paul Cant / RWC
MATERIALS USED	Mild Steel
MATERIAL GRADE(S)	S275 & S355
WELD PROCESS(ES)	135
AUDITOR RECOMMENDATION	maintained.
NUMBER OF MAJOR NONCONFORMITIES RAISED	zero
NUMBER OF MINOR NONCONFORMITIES RAISED	zero
REFERENCE TO ACCREDITATION AND LOGOS	correct
EN1090-1 CERTIFICATE NUMBER	21/3370 EN1090-1 CERTIFICATE EXPIRY DATE 09/03/2023
TYPE OF MARKING REQUIRED	UKCA mark only
NEXT AUDIT DATE(S)	15/02/2024
TYPE OF NEXT EN1090-1 AUDIT	surveillance
LOCATION(S) OF NEXT AUDIT	Unit 9, North Way Walworth Industrial Estate Andover SP105AZ
NEXT AUDIT – TOTAL AUDITOR DAYS	1 day TECHNICAL EXPERT DAYS N/A
DATE REPORT PREPARED	Fabian Mendez REPORT PREPARED BY Fabian Mendez

EXECUTIVE SUMMARY

Basis of the Audit

This audit was based on the defined Factory Production Control (FPC) system as summarised in the current FPC Manual6 Sept 2016

The audit process is based on random sampling and, therefore, nonconformities may exist which have not been identified.

Audit evidence and processes audited

Objective evidence has been audited and recorded by CfA auditor(s) in detailed notes which will be retained at CfA. This evidence supports the findings, conclusions and recommendations in this report and any nonconformities and observations raised.

We have audited the following factory production control system processes:

- enquiries, quotes, orders, review of requirements
- design
- documentation (drawings, procedures, inspection and test plans)
- purchasing, material receipt, inspection, storage and traceability
- competence and training
- maintenance and calibration
- fabrication
- outsourced processes
- inspection and test
- nonconformities and corrective actions

Findings

The following are the notable positive and other findings from the audit:

- Good technical knowledge

FPC System Conformity and Effectiveness

The FPC system conforms with applicable requirements and is effective in delivering the expected outcomes.

Evidence of FPC system capability to meet these applicable requirements and expected outcomes includes:-

- Good control over job / material traceability
- No NCs / complaints since previous assessment

Conclusions

During the audit, zero major nonconformity(s) and zero minor nonconformity(s) were identified. Observations have been raised where appropriate. Any nonconformities and observations are summarised in the “Overall Audit Findings” section of this report and are detailed in a separate “Continual Improvement Record”.

Centre for Assessment's audit objectives, as defined in the audit plan, were achieved.

The certification scope is appropriate.

Recommendation

Certification to the EN1090-1 Standard is maintained.

OVERALL AUDIT FINDINGS

Summary against the EN1090-1 requirements

The table below summarises our findings against the requirements of the EN1090-1 Standard. Where a nonconformity (NC) or observation (OBS) has been identified, the reference numbers relate to their details on the separate "Continual Improvement Record".

EN1090-1 clause	Requirement	C, NC, N/A	Minor NC ref. nos.	Major NC ref. nos.	OBS ref. nos.
6.2	Initial Type Testing				
6.3.1	General (FPC documentation, procedures, control of documents, records of inspections, tests and assessments)	C			
6.3.2	Personnel (responsibility, authority, relationship, qualifications and training of personnel involved in managing, performing and verifying)	C			
6.3.3	Equipment (weighing, measuring, testing and manufacturing equipment calibration and maintenance)	C			
6.3.4	Structural Design Process (design brief, design Standard, calculations, designs, if design is in scope)	N/A			
6.3.5	Constituent Products Used in Manufacture (material/component specification, inspection, traceability)	C			
6.3.6	Component Specification (review of requirements, preparation of specification, manufacture, implementation of inspection & test plan)	C			
6.3.7	Product Evaluation (control of characteristics, sampling)	C			
6.3.8	Nonconforming Products	C			
Use of logos reference to "Accreditation"		C			
Any other requirements not covered above: - None					

Use of the logos and references to accredited certification

Status	Summary of evidence checked, comments and, where necessary, any observations or nonconformities raised on the Continual Improvement Record
correct	Logo not used other than on the 1090 certificates that are on display in reception. Checked other FPC documentation, delivery notes, quotes, email footers etc.

Note: Where there is incorrect use of either the certification body, accreditation body or the product certification logos or incorrect reference to accredited certification, this will be raised by the lead auditor on the "Continual Improvement Record" and corrective action must be defined and implemented by Precision Fabrications Andover Ltd .

Requirements for Closure of Nonconformities

If nonconformities have been raised during the audit, the following notes define the requirements on Precision Fabrications Andover Ltd to enable these to be closed off by Centre for Assessment.

Closing out nonconformities identified at initial certification audits:

1. Where minor nonconformities have been identified, Precision Fabrications Andover Ltd must evaluate their causes and must define the actions to prevent their recurrence on the Centre for Assessment's "Continual Improvement Record". This record must be submitted directly to the lead auditor, Fabian Mendez , within 30 days. Also, Precision Fabrications Andover Ltd must submit evidence to demonstrate that these actions have been implemented effectively. The Centre for Assessment will not consider the recommendation for certification until sufficient evidence is provided to and agreed by the lead auditor, Fabian Mendez . Where possible, please submit the "Continual Improvement Record" and supporting evidence by email to the following email address fabian.mendez.oms@gmail.com. Unless there are exceptional circumstances, a re-

audit will be necessary, with additional costs, if the completed “Continual Improvement Record” and satisfactory evidence is not submitted to the lead auditor within this 30 day period.

2. Where major nonconformities have been identified, Precision Fabrications Andover Ltd must evaluate their causes and must define the actions to prevent their recurrence on the Centre for Assessment’s “Continual Improvement Record”. This record must be submitted directly to the lead auditor, Fabian Mendez , within 30 days. The lead auditor will need to make a return visit to Precision Fabrications Andover Ltd to close out the nonconformities, normally within 3 months, unless it is agreed by the lead auditor at the closing meeting that evidence can be submitted by e-mail. If the Lead Auditor is unable to verify the implementation of action for a major non-conformity within 6 months of the last day of the audit, Precision Fabrications Andover Ltd the certification audit will need to be repeated.
3. Where the same minor nonconformities are identified again at subsequent visits, these may be escalated to major nonconformities

Closing out nonconformities identified at surveillance audits:

4. Where minor nonconformities have been identified, evidence of closing them out need not be submitted to the Centre for Assessment, since this evidence will be verified by the auditor at the next visit or desktop review.
5. Where major nonconformities have been identified, Precision Fabrications Andover Ltd must evaluate their causes and must define the actions to prevent their recurrence on the Centre for Assessment’s “Continual Improvement Record”. This record must be submitted directly to the lead auditor, Fabian Mendez , within 30 days. The lead auditor will need to make a return visit to Precision Fabrications Andover Ltd to close out the nonconformities, normally within 3 months, unless it is agreed by the lead auditor at the closing meeting that evidence can be submitted by e-mail.
6. Where the same minor nonconformities are identified again at subsequent visits, these may be escalated to major nonconformities.

DETAILED PLAN FOR NEXT AUDIT

Location(s) of audit:	Unit 9, North Way Walworth Industrial Estate Andover SP105AZ
Duration of audit (auditor days):	1 day
Duration (technical expert days):	N/A
Date(s) of audit:	15/02/2024
Audit type:	surveillance

Audit objectives:

To establish confidence that the factory production control system is compliant with the EN 1090-1 Standard, including establishing the implementation and effectiveness of:

a) operational control of the factory production control system
b) links between the normative requirements of the EN1090-1 Standard including the customer's requirements, design, traceability and certification of materials, suppliers, factory production controls, equipment calibration, responsibilities, competence of personnel
d) treatment of nonconformities and complaints
d) actions taken to address nonconformities from the previous CfA audit
e) use of certification and accreditation marks

Timetable / processes to be audited

Date/time/auditor	Business area/process	ICT/Onsite
9	Opening meeting	On-site
	Enforcements / prosecutions / involvement of regulatory authority	On-site
	Follow up on previous CfA audit findings	On-site
	Site tour	On-site
	Control of documents and records (manual, procedures, drawings, specifications, standards, CAD, backups, access to Standards)	On-site
	Personnel. competence and training (job descriptions, RWC, welder certificates, CVs, prolongation, competences of others involved in structural steelwork)	On-site
	Production and test equipment including maintenance (planned and reactive) and calibration (weld equipment and measuring equipment)	On-site
12:30	Lunch	
	Constituent products (procedures , goods received, material grades, identification, segregation and storage); purchasing (including supplier evaluation and approved supplier list)	On-site
	Product specifications, identification and traceability. Verification of specifications, including technical review	On-site
	Production evaluation (processes and procedures for inspection and testing before, during and after welding). Inspection and test methods.	On-site
	Control of subcontracted processes	On-site
	Non-conforming products (procedure and records)	On-site
3.15	Use of the UKAS logo and product marking	On-site
	Report writing	On-site
4.30	Closing meeting	On-site

Arrangements for the next audit:

1. **Certification Expiry:** Your EN1090-1 certificate will have a 12 month expiry date. In order to ensure continuity of certification and, therefore, to enable Precision Fabrications Andover Ltd to continue to legally UKCA mark its products, the next audit will need to be carried out sufficiently in advance of the certificate expiry date. We are required by UKAS to define any lapses in the certification on any future certificates.

2. **Pre-Audit Information**: Prior to the next audit, Precision Fabrications Andover Ltd is required to provide information such as organisational, fabrication and equipment details, scope of certification, numbers of employees and locations. In addition, Precision Fabrications Andover Ltd is required to confirm if there have been any changes to the following EN1090-1 requirements:-
    a) new or changed essential facilities;
    b) change of responsible welding coordinator;
    c) new welding processes, type of parent metal and the associated welding procedure qualification record (WPQR);
    d) new essential equipment.

    Centre for Assessment will review the above information prior to the next audit and, based on UKAS requirements, it may then be necessary to increase the number of audit days and to amend the above audit plan.
3. **Audit Timescales**: In order to ensure continuity of certification and, therefore, to enable Precision Fabrications Andover Ltd to continue to legally mark its products, the audit will need to be carried out sufficiently in advance of the certificate expiry date. Centre for Assessment is required to define any lapses in the certification on any future certificates.
4. **Changes to Agreed Audit Dates**: Your next audit will automatically be scheduled to take place on the date(s) agreed. Any changes to dates must be requested in writing to Centre for Assessment. Please refer to Centre for Assessment's terms and conditions for cancellation notice periods and costs.